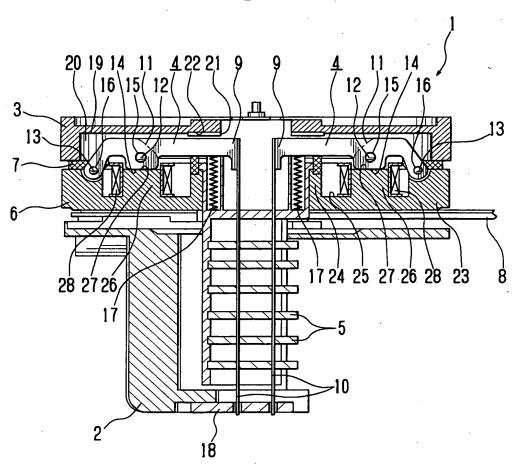


Fig. 1



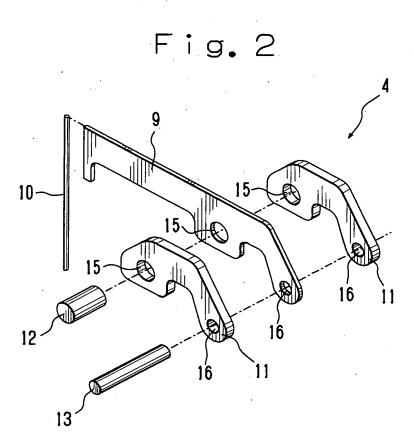


Fig. 3

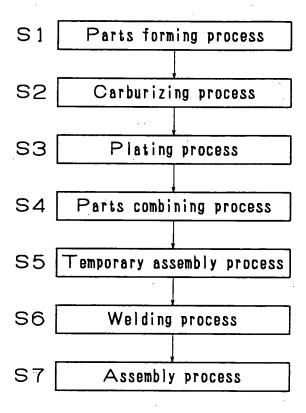


Fig. 4

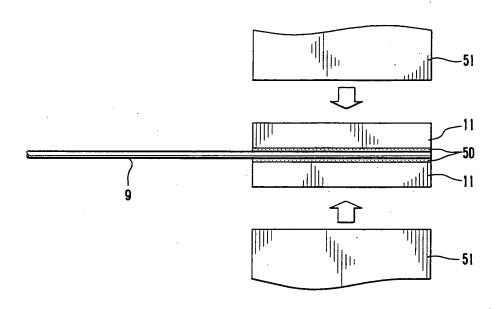


Fig. 5

	Welding current(A)	Pressure (kgf)	Size of electrodes (mm)	Waveform of welding current	Weld strength (kgf·cm)
Example	3600	24	4X6	1+7+5+9+2	5, 8
Comparative example	3750	24	4X6	1+7+5+9+6	5. 5

